



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3078-042
Job Sheet 209530



Part No: D3078-042

Job Qty: 10 pcs

Part Name: Step Assembly, Hi Short RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/20

Job Tracking No:

Due Date: 8/10/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP REV:B 15.11.12 REV:C3 DD VERF:JLM
IPP REV:C 16.03.15 DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs			0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 5	10 pcs			0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		



Container No: S294006



Part: D3078-042

Job No: 209530

Serial No/Batch: S294006

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 08/13/20

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			QC 5 - 81	
			QC 5 - 82	
130 Large Fab - Welded Assy-2-B4B	10 pcs	0.00 11.99	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	DAS
			Large Fab - 5 - B4B	24
			Large Fab - 6 - B4B	9-89
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
				AUG 17 2020
140 QC 9	10 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	
			QC 9 - 43	
			QC 9 - 50	
			QC 9 - 9	
150 QC 5	10 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
160 Handfinish - 1-1 Chemical-B4B	10 pcs	0.00 2.08	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	

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170 QC 7	10 pcs	0.00 0.00	Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
			QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
200 Large Fab - Welded Assy-3-B4B	10 pcs	0.00 11.99	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
210 QC 10	10 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	
			QC 10 - 50	
			QC 10 - 58	
			QC 10 - 9	

2020/08/19

DAS
24
9-89

AUG 2 0 2020

DAS
24
9-89

AUG 2 4 2020

DAS
81
9-89

AUG 2 7 2020

220 QC 5	10 pcs	0.00 0.00	QC 10 - 68	
			QC 10 - 81	
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	DAS
			QC 5 - 30	81
			QC 5 - 40	9-89
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
230 Handfinish - 6-1- Touch Up- B4B	10 pcs	0.00 2.08	Handfinish - 6 - 1 - B4B	
			Handfinish - 6 - 2 - B4B	
			Handfinish - 6 - 3 - B4B	
			Handfinish - 6 - 4 - B4B	
			Handfinish - 6 - 5 - B4B	
			Handfinish - 6 - 6 - B4B	
			Handfinish - 6 - 7 - B4B	
			Handfinish - 6 - 8 - B4B	
			Handfinish - 6 - 9 - B4B	
			Handfinish - 6 - 10 - B4B	
			Handfinish - 6 - 11 - B4B	
			Handfinish - 6 - 12 - B4B	
			Handfinish - 6 - 13 - B4B	
			Handfinish - 6 - 14 - B4B	
			Handfinish - 6 - 15 - B4B	
			Handfinish - 6 - 16 - B4B	
			Handfinish - 6 - 17 - B4B	
			Handfinish - 6 - 18 - B4B	
			Handfinish - 6 - 19 - B4B	
			Handfinish - 6 - 20 - B4B	
			Handfinish - 6 - 21 - B4B	
			Handfinish - 6 - 22 - B4B	
240 Powdercoat - 1 White Gl(A)- B4B	10 pcs	0.00 1.91	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
250 Handfinish - 3-1- WingWalk- B4B	10 pcs	0.00 1.25	Handfinish - 3 - 1 - B4B	
			Handfinish - 3 - 2 - B4B	
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
260 QC 3	10 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	DAS
			QC 3 - 17	81
			QC 3 - 18	9-89
			QC 3 - 2	

AUG 27 2020

20-08-27

83 9-89

20-08-28

83 9-89

20-08-20

AUG 31 2020

		QC 3 - 28	
		QC 3 - 3	
		QC 3 - 30	
		QC 3 - 34	
		QC 3 - 36	
		QC 3 - 41	
		QC 3 - 51	
		QC 3 - 58	
		QC 3 - 59	
		QC 3 - 68	
		QC 3 - 9	
		QC 3 - 40	
		QC 3 - 19	
		QC 3 - 43	
		QC 3 - 24	
		QC 3 - 61	
		QC 3 - 81	
		QC 3 - 82	
		QC 3 - 87	
290 Packaging 3-1 - Stock - B4B	10 pcs	0.00 0.00 Packaging 3 - 1 - B4B	
		Packaging 3 - 2 - B4B	
		Packaging 3 - 3 - B4B	
		Packaging 3 - 4 - B4B	
		Packaging 3 - 5 - B4B	
		Packaging 3 - 6 - B4B	
		Packaging 3 - 7 - B4B	
		Packaging 3 - 8 - B4B	
		Packaging 3 - 9 - B4B	
		Packaging 3 - 10 - B4B	
		Packaging 3 - 11 - B4B	
		Packaging 3 - 12 - B4B	
		Packaging 3 - 13 - B4B	
		Packaging 3 - 14 - B4B	
		Packaging 3 - 15 - B4B	
		Packaging 3 - 16 - B4B	
		Packaging 3 - 17 - B4B	
		Packaging 3 - 18 - B4B	
		Packaging 3 - 19 - B4B	
		Packaging 3 - 20 - B4B	
		Packaging 3 - 21 - B4B	
		Packaging 3 - 22 - B4B	
		Packaging 3 - 23 - B4B	
		Packaging 3 - 24 - B4B	DAS
		Packaging 3 - 25 - B4B	72
		Packaging 3 - 26 - B4B	9-89
		Packaging 3 - 27 - B4B	
		Packaging 3 - 28 - B4B	
		Packaging 3 - 29 - B4B	
		Packaging 3 - 30 - B4B	
		Packaging 3 - 31 - B4B	
		Packaging 3 - 32 - B4B	
		Packaging 3 - 33 - B4B	
		Packaging 3 - 34 - B4B	
		Packaging 3 - 35 - B4B	
		Packaging 3 - 36 - B4B	
		Packaging 3 - 37 - B4B	
300 QC 21 - SA	10 pcs	0.00 0.00 QC 21 - SA - 21	DAS
		QC 21 - SA - 70	77
		QC 21 - SA - 53	9-89

Part Op 110 - (Fabricate per Dwg) 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg Descriptions: D3078 using Jig DT8680 for rivets. 3-Deburr & buff scratches

120 - QC5- Inspect part completeness to step on W/O

130 - (Weld per dwg A/R Aluminum rod Batch: 139019 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 139019 3-Grind End Plate flush

140 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (QC7-Inspect Chemical Conversion Coat)

200 - (Weld per dwg A/R Aluminum rod Batch: 139019 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 139019 5-Grind End Plate flush

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (QC5- Inspect part completeness to step on W/O)

230 - (Touch up alodine)

240 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 11:30 OVEN TEMPERATURE: 320°

FINISH TIME: 8:10

250 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

260 - (QC3- Inspect Part Finish)

290 - Identify as per dwg & Stock Location: _____)

300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	5 pcs (.5 ea)	110-Large Fab - Steps - 1	<u>5269726</u>
D3067-1	End Plate	20 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5267468</u>
D3219-3	Plate	20 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5207480</u> <u>5229367</u>
D3065-041	Step Leg Assembly	10 pcs (1 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5292376</u> <u>5294708</u>
D3066-1	Spacer	20 pcs (2 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5268849</u>
MS20600-AD4W4	Rivet	160 Ea (16 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5251801</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	5	261	0
130-Large Fab - Welded Assy-2- B4B	D3067-1	20	59	0
	D3219-3	20	66	0
200-Large Fab - Welded Assy-3- B4B	D3065-041	10	18	0
	D3066-1	20	139	0
	MS20600-AD4W4	160	1,977	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					